

## **Process Analysis Sheet**



andardized Work Chart Process/Trend	tandardized Work Chart		Process Name	Tool No.	Machine	Takt Time (sec's)	65		No Ops	Op 1 TCT	Op 2 TCT	Ор 3 ТСТ	Op 4 TCT	Op 5 TCT
2) Low 10 color first color from Correct Color for the Col		8/12/2021	Lamination/Welding	8	Lam #1	Cycle Time (sec's)			4	111/55.5 Sec's	55 Sec's	48 Sec's	45 Sec's	Sec
	C-Pillar LH	C.Pilar L.H. LH. LH. WP.Rack	2)Laminati 3)Move 2 W	we w	lder #1  ) Weld 2)Trim  1) Weld 2)Trim  Install llation Bag	- 80 70 60 50 40 30 20	3 -65	Load Move 2 Wip Laminate  130 130 130 130 130  120 120 120 120 120 120 120 120 120 120	Takt Differentation Ta  130 130 130  112 105 135 14 15 15 15 15 15 15 15 15 15 15 15 15 15	140	Total — Total — Total — Total — Total — Bag — Takt — Sharp — Sharp — Takt — Sharp — Sharp — Takt — Sharp	akt Trim Weld  65 65 66 6  88 49 49 49 49 49 49 49 49 49 49 49 49 49	Takt Differentation  5 65 65 65  8 56  10 10 10 10 10 10 10 10 10 10 10 10 10 1	50 70 60 50 14 40 - 30 20 10 10 10 10 10 10 10 10 10 10 10 10 10